



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D5737-041
Job Sheet 203338

Accounting Job RD19-1069-01



Part No: D5737-041

Job Qty: 1 pcs

Part Name: FWD Wearplate Assembly, LH



Part Weight: 0 lbs

Status: New

Job Created: 11/15/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: URF 19-1208 DWG D5737 Rev.A IPP Rev. A 19.11.11 New issue DP Verify DD

Ship Via:

POSITIVE RECALL

EFFECTIVE 19/11/19 AUTH *MD*
RELEASED 9-89 DATE 12.12.03
Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Large Fab - Welded Assy-1	1 pcs	11/29/19		0.00	0.80	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	11/29/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	11/29/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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CANADA
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Container No: S236233



Part: D5737-041

Job No: 203338

Serial No/Batch: S236233

Revision: U/R Rev A

Inspector:

Exp Date:

Instructions:

Date: 11/29/19

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[illegible]

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	11/29/19	0.00 0.00	QC 21 - SA - 21 ✓	525 461
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-00

Part Op 100 - 1- Weld D5737-041 to wearplate as per dwg D5737 304 S.S. Welding Rod BATCH #: M176585 2-
 Descriptions: Transfer drill holes in bar 3- Use DT to check fit after welding 4- ENSURE WELDED CLAMP FITS AROUND A
 3.62" DIAMETER WITH 0.375-0.500 THREAD EXPOSED WHEN SNUG.
 110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 150 - BATCH: 5227557 COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040
 THICK, PER DART QSI 005 4.9.
 160 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location:
 180 - QC21- Final Inspection - Work Order Release

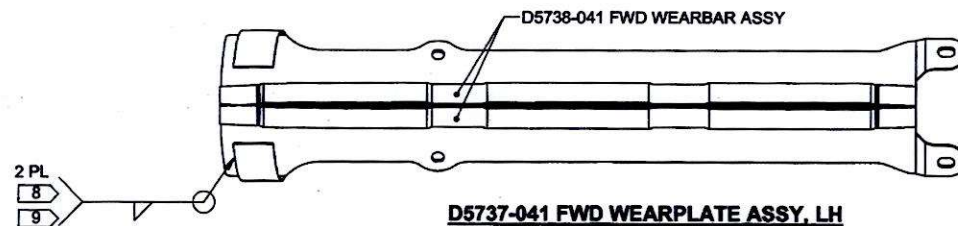
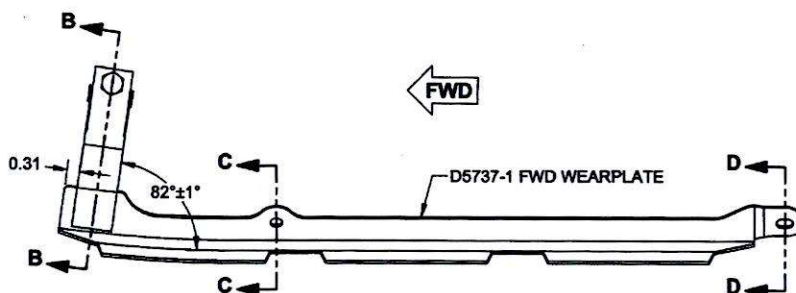
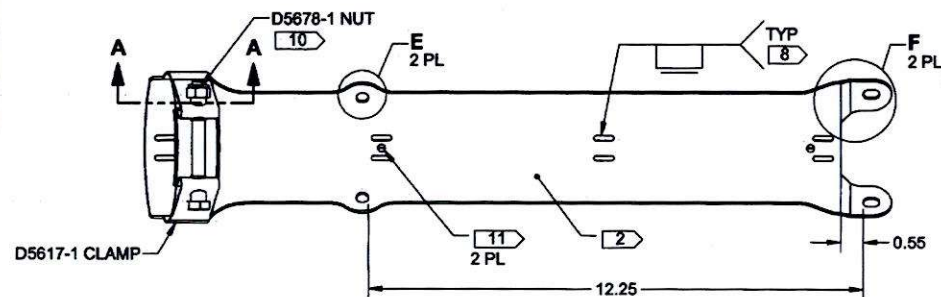
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D5617-1	Clamp	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5225562
D5678-1	Hex Nut	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5225708
D5737-1	FWD Weaplate	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5233285
D5738-041	FWD Wearbar Assembly	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5235135

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D5617-1	1	16	0
	D5678-1	1	37	0
	D5737-1	1	0	0
	D5738-041	2	0	0

Part Specifications	
Specifications could not be found.	

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QTY -041	P/N	DESCRIPTION
X	D5737-041	FWD WEARPLATE ASSY, LH
1	D5737-1	FWD WEARPLATE
2	D5738-041	FWD WEARBAR ASSY
1	D5617-1	CLAMP
1	D5678-1	NUT



D5737-041 FWD WEARPLATE ASSY, LH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 203558 M/L
19-11-15

UNDER REVIEW

URF 19-1208 19.11.07 (VM)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING PER DART QSI 005 4.9
MASK D5617-1 CLAMPS PRIOR TO FINISH
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5737-041" AND S/N PER DART QSI 044 6.1
- 7) WEIGHT: 3.38 lbs
- 8) WELD PER DART QSI 004
- 9) ENSURE WELDED CLAMP FITS AROUND A 3.62 DIAMETER WITH 0.375-0.500 THREADS EXPOSED WHEN SNUG
- 10) INSTALL HAND TIGHT ONLY
- 11) TRANSFER DRILL $\phi 0.188$ DRAIN HOLES FROM WEARPLATE THRU WEARBAR, OPEN HOLES TO $\phi 0.188$ AFTER FINISH IF REQUIRED

APPROVED	A	NEW ISSUE	ZF	19.08.22
	REV.	DESCRIPTION	BY	DATE
	DESIGN	ZF	DART AEROSPACE USA, INC. HILLSBORO, OR	
	DRAWN	ZF		
	CHECKED	MW	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5737	SHEET 1 OF 9
APPROVED			TITLE	SCALE
DE APPR.			TRAINING WEARPLATES	NTS
DATE			19.08.22	

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WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>203338</u> Part No. <u>D5737-041</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	<table style="width: 100%;"> <tr> <th colspan="4" style="text-align: center;">DEPARTMENT/PROCESS</th> </tr> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Eng. (Non-AW) ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Water Jet ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Supplier Quality ☐</td> </tr> </table>	DEPARTMENT/PROCESS				Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐
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Date : <u>12-0012-19-12-05</u>	Sequence #: <u>160</u>	QTY Affected : <u>1</u>	MRB (QSI042) <u>NO 19.12.11</u>
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Description Work Order Deviation	Disposition	
clamp angle 82° ± 1° is actually 85°	Clamp will snug up against tube when torqued. Acceptable as is. Dwg will be amended to increase tolerance for manufacturability	Completed By <u>NO 19.12.11</u> Lead hand / Supervisor QC / QA Coordinator

Root Cause	FAULT CATEGORY																																														
<table style="width: 100%;"> <tr><td>Operator</td><td>☐</td></tr> <tr><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td></tr> <tr><td>Handling/Preservation</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td></tr> <tr><td>Product Improvement</td><td>☐</td></tr> <tr><td>Process Improvement</td><td>☐</td></tr> <tr><td>Human Factors</td><td>☐</td></tr> </table>	Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	<table style="width: 100%;"> <tr><td>☐ Pressure/Forced</td><td>☐ Contamination</td><td>☐ Power Loss/Surge</td><td>☐ Positioned Wrong</td></tr> <tr><td>☐ Bending</td><td>☐ Misaligned/off center</td><td>☐ Folio/Program</td><td>☐ Outside Tolerance</td></tr> <tr><td>☐ Crushing</td><td>☐ BOM/Route</td><td>☐ Grain Direction</td><td>☐ Drawing</td></tr> <tr><td>☐ Cracks</td><td>☐ Broken/Damage/Defect</td><td>☐ Weld</td><td>☐ Finish</td></tr> <tr><td>☐ Crimp/Kink/Ripple/Wave/Twist</td><td>☐ Incomplete/Unclear Instructions</td><td>☐ Wrong Stock Pulled</td><td>☐ Part Lost/Missing</td></tr> <tr><td>☐ Marks/Chatter</td><td>☐ Drill Holes</td><td>☐ Out of Sequence</td><td>☐ Misread</td></tr> <tr><td>☐ Mislabeled</td><td>☐ Fit/Function</td><td>☐ Off-set/Set-up</td><td></td></tr> </table>	☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up		Other/Details:	
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